切削條件表 X-BTB 2T MILLING CONDITIONS

被切削材 Work Material	調質鋼/預硬鋼 *Prehardened Steels* : **NAK80 : 1.2083 : AISI420 : M310** (HRc36~45)
冷卻方式 Coolant Type	乾式切削 Dry coolant

型號 Type No.	刀具伸長量 Extension Length (mm)	切削速度 Cutting Speed (m/min)	迴轉速度 Speed (min^{-1})	進給速度 Feed (mm/min)	加工深度 (A_a) Depth of Cut	加工寬度 (A_p) Width of Cut	加工方式 Milling Type
X-BTB0802	30	280	10000~11000	2200~2600	0.18~0.23	0.36~0.46	3D銑 3D MILLING
X-BTB0802	30	330	12000~13000	3600~4000	0.08~0.13	0.16~0.26	3D銑 3D MILLING
X-BTB0802	50	185	6700~7300	1400~1800	0.15~0.2	0.3~0.4	3D銑 3D MILLING
X-BTB0802	50	225	8300~8800	2000~2400	0.08~0.1	0.16~0.2	3D銑 3D MILLING
X-BTB0802	70	175	6000~7000	1400~1800	0.08~0.1	0.16~0.2	3D銑 3D MILLING
X-BTB1002	40	290	8700~9200	2200~2600	0.23~0.28	0.46~0.56	3D銑 3D MILLING
X-BTB1002	40	290	8700~9200	3200~3600	0.1~0.15	0.2~0.3	3D銑 3D MILLING
X-BTB1002	60	290	8700~9200	1600~2000	0.1~0.15	0.2~0.3	3D銑 3D MILLING
X-BTB1002	60	290	8700~9200	2000~2400	0.06~0.1	0.12~0.2	3D銑 3D MILLING
X-BTB1002	100	195	5700~6200	1000~1200	0.1~0.14	0.2~0.28	3D銑 3D MILLING
X-BTB1002	100	260	7700~8200	1200~1500	0.06~0.1	0.12~0.2	3D銑 3D MILLING
X-BTB1202	40	325	8200~8600	2100~2500	0.28~0.3	0.56~0.6	3D銑 3D MILLING
X-BTB1202	40	325	8200~8600	2800~3200	0.1~0.15	0.2~0.3	3D銑 3D MILLING
X-BTB1202	60	325	8200~8600	1600~2000	0.2~0.25	0.4~0.5	3D銑 3D MILLING
X-BTB1202	60	325	8200~8600	2200~2600	0.1~0.15	0.2~0.3	3D銑 3D MILLING
X-BTB1202	100	220	5300~5800	800~1200	0.1~0.15	0.2~0.3	3D銑 3D MILLING
X-BTB1602	60	230	4000~4500	1600~2000	0.23~0.28	0.46~0.56	3D銑 3D MILLING
X-BTB1602	60	305	5500~6000	2600~3000	0.12~0.17	0.24~0.34	3D銑 3D MILLING
X-BTB1602	100	175	3000~3500	1400~1800	0.23~0.28	0.46~0.56	3D銑 3D MILLING
X-BTB1602	100	230	4000~4500	2000~2400	0.12~0.17	0.24~0.34	3D銑 3D MILLING
X-BTB1602	140	140	2300~2800	1200~1500	0.1~0.15	0.2~0.3	3D銑 3D MILLING
X-BTB2002	80	330	4700~5200	1600~2000	0.23~0.28	0.46~0.56	3D銑 3D MILLING
X-BTB2002	80	380	5500~6000	2000~2400	0.12~0.17	0.24~0.34	3D銑 3D MILLING
X-BTB2002	130	160	2000~2500	1100~1400	0.2~0.25	0.4~0.5	3D銑 3D MILLING
X-BTB2002	130	220	3000~3500	1200~1600	0.12~0.17	0.24~0.34	3D銑 3D MILLING
X-BTB2002	180	140	1800~2200	1000~1300	0.1~0.15	0.2~0.3	3D銑 3D MILLING
X-BTB2502	80	330	3500~4000	1300~1700	0.23~0.28	0.46~0.56	3D銑 3D MILLING
X-BTB2502	80	350	4000~4500	1800~2200	0.12~0.17	0.24~0.34	3D銑 3D MILLING
X-BTB2502	130	220	2400~2800	1000~1400	0.2~0.25	0.4~0.5	3D銑 3D MILLING
X-BTB2502	130	300	3400~3800	1300~1700	0.12~0.17	0.24~0.34	3D銑 3D MILLING
X-BTB2502	180	240	2500~3000	1100~1400	0.1~0.15	0.2~0.3	3D銑 3D MILLING
X-BTB3202	80	330	2700~3200	1100~1500	0.23~0.28	0.46~0.56	3D銑 3D MILLING
X-BTB3202	80	370	3500~4000	1500~1900	0.12~0.17	0.24~0.34	3D銑 3D MILLING
X-BTB3202	140	280	2400~2800	900~1300	0.2~0.25	0.4~0.5	3D銑 3D MILLING
X-BTB3202	140	340	3200~3700	1200~1600	0.12~0.17	0.24~0.34	3D銑 3D MILLING
X-BTB3202	200	220	1800~2200	800~1200	0.1~0.15	0.2~0.3	3D銑 3D MILLING

附註 Note

1. 由於機器剛性及主軸扭力不同，加工時若有尖銳聲音，請調降轉速(S)及進給(F)。
2. 使用BT50 (SK50/HSK100A) 刀把夾持之機器，可視情況調高轉速(S)及進給(F)。

1. Due to spindle torque and the rigidity of machine differs, please lower the Speed(S) and Feed(F) if hearing sharp voices while milling.
2. For the machine use with holder of BT50(SK50/HSK100A), please higher Speed(S) and Feed(F) according to the cutting condition.